

OLD STYLE - No
packet

Dart Aerospace Ltd.

Date: Wednesday, 3/8/2006 1:48:23 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STA 155 BRACKET
Job Number : 26164	
Estimate Number : 11039	
P.O. Number : N/A	Part Number : D28041
This Issue : 3/8/2006 S.O. No. : N/A	Drawing Number : D2804 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : N/A	Material : N/A
Written By : <u>See comment below</u>	Due Date : 3/15/2006 Qty: 4 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est. A00.11.06 New Issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X12000	6061-T6 Bar .50" x 12.0"
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Comment: Qty.: 0.7875 f(s)/Unit Total : 3.1500 f(s)

6061-T6 Bar .50" x 12.0"

Material: 6061-T6 bar 12.00" x 0.50"

Batch: M100046

TML 06/03/10

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks per template DT8534

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA103

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 26/03/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 1:48:23 PM

User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET

Job Number: 26164

Part Number: D28041

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



U 06-0313

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

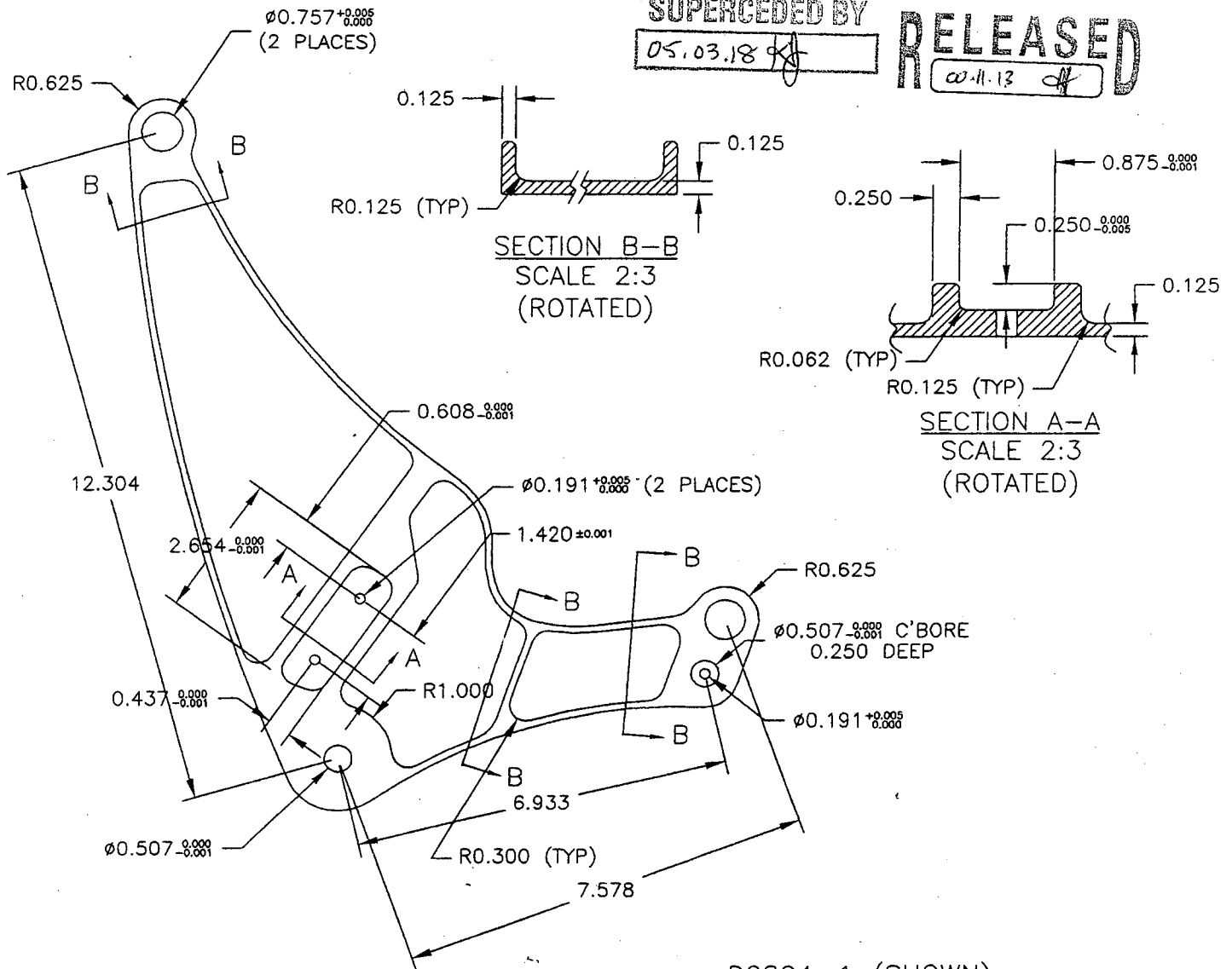


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2804	REV. A SHEET 1 OF 2
DATE 00.11.07		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
A1	01.03.14	ADD D2804-043/-044 CP	

SUPERCEDED BY

05.03.18

RELEASED
00.11.13



D2804-1 (SHOWN)
D2804-2 (OPPOSITE)

MACHINE PER DRAWING FILE "D2804-A1.DWG"

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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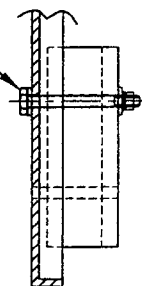
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2804	REV. A SHEET 2 OF 2
DATE 00.11.07	TITLE STA 155 BRACKET		SCALE 1:3

RELEASED
00.11.13 #

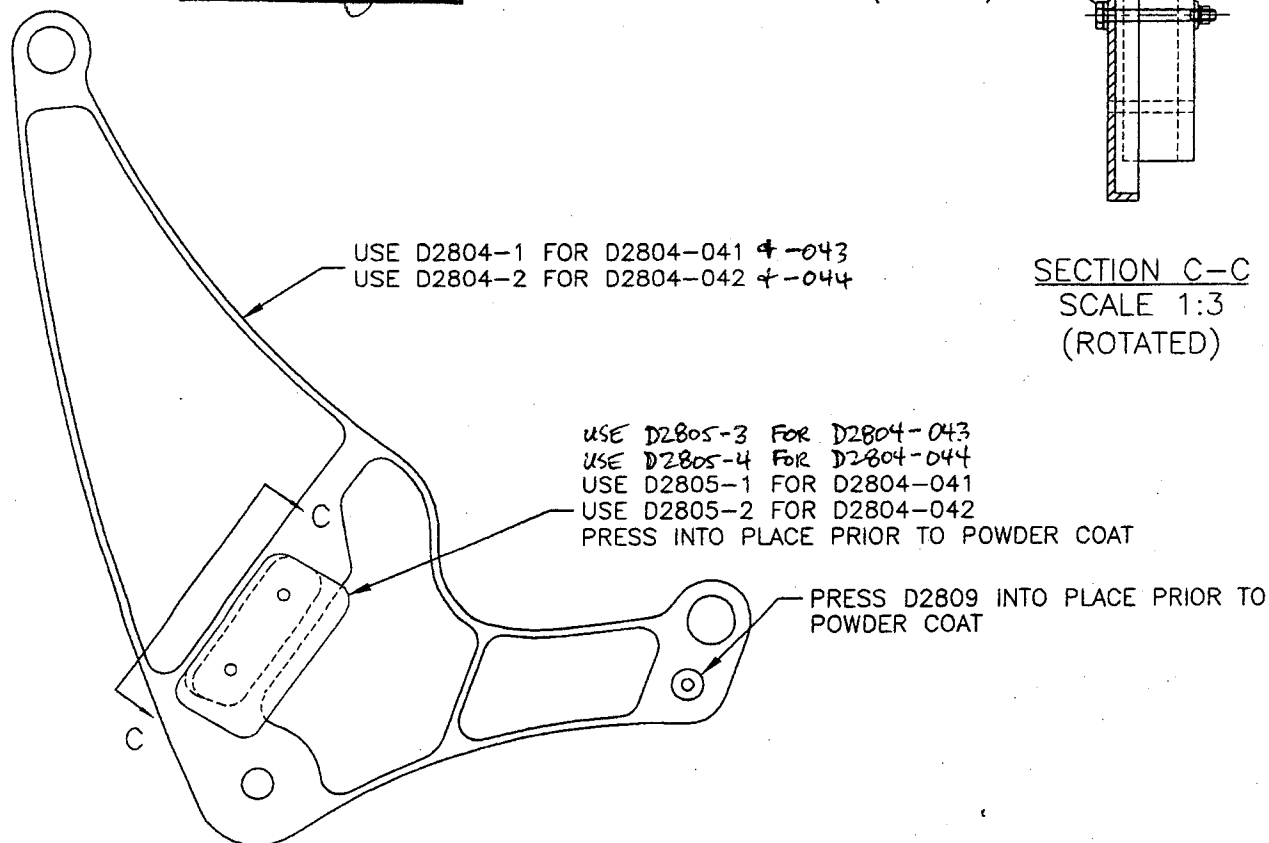
SUPERCEDED BY

05.03.18 #

AN3-16A BOLT (1)
AN960JD10 WASHER (2)
MS21042L3 NUT (1)
(1 PLACE)



SECTION C-C
SCALE 1:3
(ROTATED)



D2804-041 ASSEMBLY (SHOWN) → D2804-043 SIMILAR
D2804-042 ASSEMBLY (OPPOSITE) → D2804-044 SIMILAR

FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY
SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX
(4.3.5.8) PER DART QSI 005 4.3

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OLD STYLE - No pockets

Dart Aerospace Ltd.

Wednesday, 3/8/2006 1:48:23 PM

Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 26164
 Estimate Number : 11039
 P.O. Number :
 This Issue : 3/8/2006 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : SMALL /MED FAB
 Previous Run :
 Written By :
 Checked & Approved By :
 Comment : Est. A00.11.06 New Issue EC

Drawing Name : STA 155 BRACKET
 Part Number : D28041
 Drawing Number : D2804 REV B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 3/15/2006 Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X12000 6061-T6 Bar .50" x 12.0"



Comment: Qty.: 0.7875 f(s)/Unit Total: 3.1500 f(s)
 6061-T6 Bar .50" x 12.0"

Material: 6061-T6 bar 12.00" x 0.50"

Batch: M100046

ml 06/03/10

4

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blanks per template DT8534

ml 06/03/10

4

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio FA103

ml 06/03/10

4

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/03/10

4

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MS 06/03/10

4

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Tumble & Deburr

ml 06/03/10

4

REFERENCE ONLY

Wednesday, 3/8/2006 1:48:23 PM
Linda Lacelle

User:

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET

Job Number: 26164

Part Number: D28041

Job Number:



Seq. #:

Machine Or Operation:

Description:

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MS / IL 06/03/10

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06-03-12 (4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/03/13 (4)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

QD 06/03/13 (4)

Job Completion



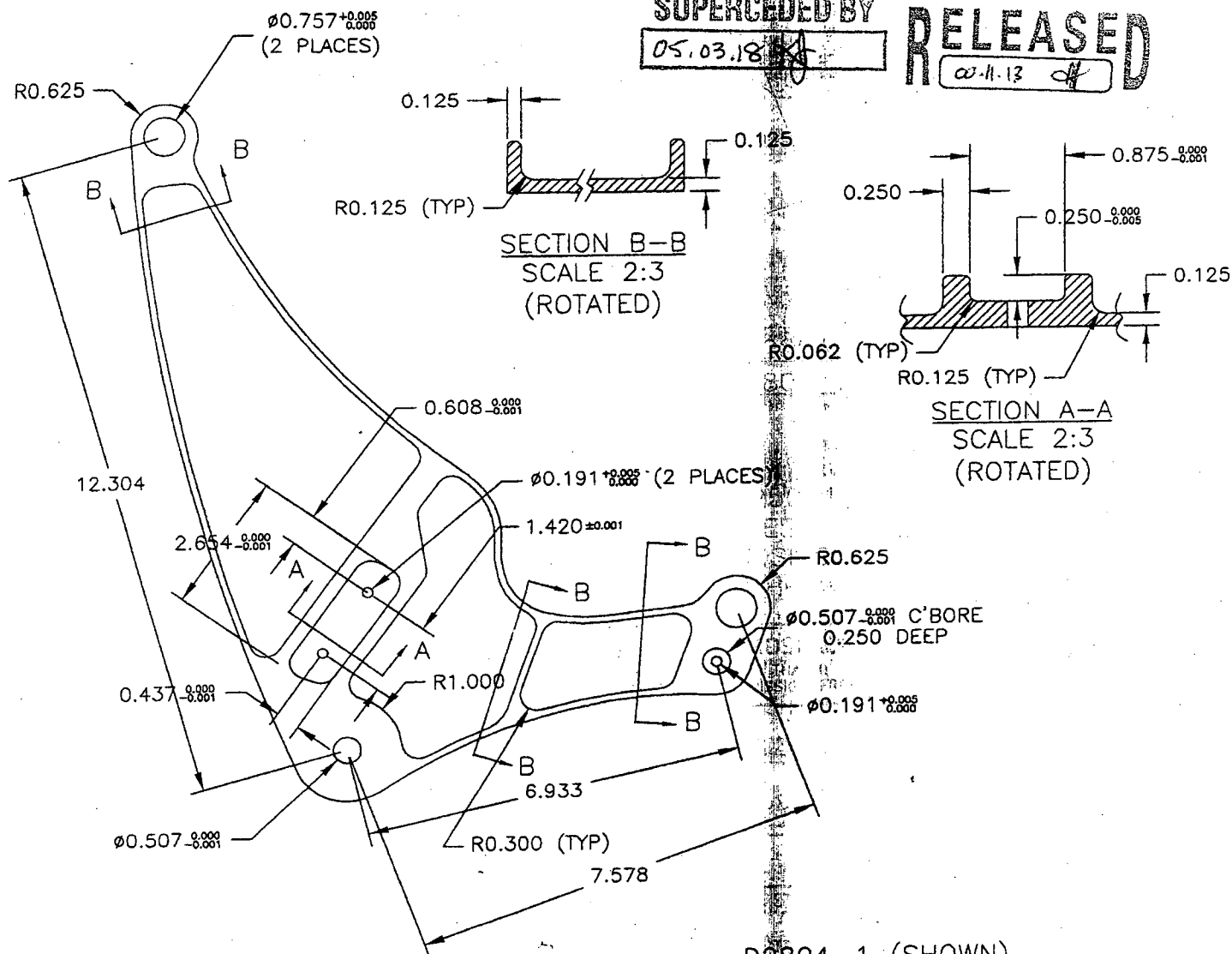


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED	DRAWING NO. D2804	REV. A SHEET 1 OF 2
DATE 00.11.07		FILE ATA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
A1	01.03.14	ADD D2804-043/-044 CP	

SUPERCEDED BY

05.03.18

RELEASED
00.11.13



D2804-1 (SHOWN)
D2804-2 (OPPOSITE)

MACHINE PER DRAWING FILE "D2804-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-200/11) 0.500 THICK
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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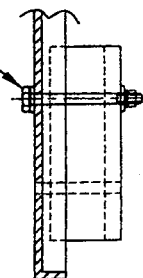
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED #	DRAWING NO. D2804	REV. A SHEET 2 OF 2
DATE 00.11.07		TITLE STA 155 BRACKET	SCALE 1:3

RELEASED
00.11.13 #

SUPERCEDED BY

05.03.18 #

AN3-16A BOLT (1)
AN960JD10 WASHER (2)
MS21012L3 NUT (1)
(1 PLACE)



SECTION C-C
SCALE 1:3
(ROTATED)

USE D2804-1 FOR D2804-041 + -043
USE D2804-2 FOR D2804-042 + -044

USE D2805-3 FOR D2804-043
USE D2805-4 FOR D2804-044
USE D2805-1 FOR D2804-041
USE D2805-2 FOR D2804-042
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE PRIOR TO
POWDER COAT

D2804-041 ASSEMBLY (SHOWN) → D2804-043 SIMILAR
D2804-042 ASSEMBLY (OPPOSITE) → D2804-044 SIMILAR

FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY
SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX
(4.3.5.8) PER DART QSI 005 4.3

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DART AEROSPACE LTD		Work Order: 26164
Description: Bracket		Part Number: D2804-1
Inspection Dwg: D2804	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.825	+/-0.010					NO DIMENSION
Ø0.757	+0.005/-0.000	Ø0.760	✓			
0.608	+0.000/-0.001	0.608	✓			
Ø0.191	+0.005/-0.000	Ø0.192	✓			
1.420	+/-0.001	1.420	✓			
Ø0.507	+0.000/-0.001	Ø0.507	✓			
0.250 deep	+/-0.010	0.247	✓			
Ø0.507	+0.000/-0.001	Ø0.507	✓			
Ø0.191	+0.005/-0.000	Ø0.192	✓			
6.933	+/-0.010	6.932	✓			
7.578	+/-0.010	7.576	✓			
0.437	+0.000/-0.001	0.437	✓			
2.654	+0.000/-0.001	2.654	✓			
12.304	+/-0.010	12.302	✓			
0.125	+/-0.010	0.125	✓			
0.500	+/-0.010	0.509	✓			
0.125	+/-0.010	0.120	✓			
0.250	+/-0.010	0.249	✓			
0.875	+0.000/-0.001	0.8744	✓			
0.250	+0.000/-0.005	0.249	✓			

Measured by: JML	Audited by: J.L	Prototype Approval: N/A
Date: 06/03/10	Date: 06.03.10	Date: N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries